



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2938-1
Job Sheet 180951



Part No: D2938-1

Job Qty: 4 ea

Part Name: Saddle LH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/31/18	0.00	0.00	Start Up Machining-1		UHS 18/17/30
100	CNC Vertical Machining	4 pcs		7/31/18	0.70	4.00	HAAS1-2		
110	Mill Conv	4 pcs		7/31/18	0.00	1.00	Mill Conv 1		
120	QC	4 pcs		7/31/18	0.00	0.00	QC1		
130	QC	4 pcs		7/31/18	0.00	0.00	QC8 Machining-1		mark 18/08/18
140	HandFinish	4 pcs		7/31/18	0.00	0.19	HandFinish1		D.R 18/08/09
150	Powdercoat	4 pcs		7/31/18	0.00	0.15	Powdercoat1		UHS 18/08/18
160	QC	4 pcs		7/31/18	0.00	0.00	QC3		AUG 2 0 2018 38
170	Packaging	4 pcs		7/31/18	0.00	0.00	Packaging3-1		5/375 DAS 6 21 AUG 2 3 2018 9-89
180	QC21-SA	4 Ea		7/31/18	0.00	0.00	QC21		AUG 2 4 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & Descriptions: attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA007.

150 - START TIME: 8:30AM OVEN TEMP: 320°C FINISH TIME: 9:00AM

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	

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 www.dartaero.com



Container No: S097293



Part: D2938 - 1

Job No: 180951

Serial No/Batch: S097293

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/30/18

FAULT CATEGORY

Defect Complete/Unqualified	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	Complete/Unclear	☐	Mislabeled	☐
☐		Fit/Function	☐	Misread
☐		Misaligned/off center	☐	Turning Sequence

DART AEROSPACE LTD	Work Order:	180951
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.120	0.120	0.120	0.120		
B	0.100	0.140		0.120	0.120	0.120	0.120		
C	0.100	0.140		0.120	0.120	0.120	0.120		
D	0.210	0.230		0.226	0.170	0.120	0.120		
E	1.245	1.255		1.248	1.248	1.248	1.248		
F	1.245	1.255		1.248	1.248	1.248	1.248		
G	2.495	2.505		2.498	2.498	2.498	2.498		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.496	2.496	2.496	2.496		
K	0.257	0.262		0.257	0.257	0.257	0.257		
L	0.312	0.317		0.312	0.312	0.312	0.312		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.051	0.051	0.051	0.051		
O	0.540	0.560		0.551	0.551	0.551	0.551		
P	0.490	0.510		0.504	0.501	0.500	0.503		
Q	3.715	3.725		3.717	3.713	3.71	3.71		
R	2.720	2.760		2.743	2.743	2.743	2.743		
S	0.240	0.270		0.260	0.260	0.260	0.260		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.250	1.270		1.265	1.260	1.260	1.260		
Y	1.565	1.585		1.570	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

